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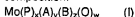
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## (54) Process for preparing nitriles.

(37) A heteroaromatic nitrile is prepared in high conversion and yield by catalytically reacting an alkyl-substituted heteroaromatic compound with molecular oxygen and ammonia in the presence of a catalyst having the following composition:



wherein x, y, z and w represent atomic ratios of phosphorus, an element A defined below, an element B defined below and oxygen to molybdenum, respectively and

(i) x and z are both 0 (zero), y is from 0.1 to 5, and A is at least one element selected from the group consisting of cerium or tungsten, or

(ii) x is from 0.1 to 7, y is from 0 to 5, z is from 0 to 5, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is at least one element selected from the group consisting of thallium, titanium, niobium and aluminum, or

(iii) x is from 0.5 to 7, y is from 0 to 5, z is from 0.01 to 2, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is vanadium, and w is defined from the valencies of molybdenum, phosphorus, the element A, the element B and the values x, y and z.

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## PROCESS FOR PREPARING NITRILES

The present invention relates to a process for preparing nitriles. More particularly, it relates to a process for producing a heteroaromatic nitrile comprising catalytically reacting an alkyl-substituted heteroaromatic compound with ammonia and molecular oxygen in a gaseous phase (namely, by ammoxidation).

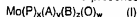
The heteroaromatic nitriles are useful as starting materials in the preparation of medicines or agricultural chemicals.

Japanese Patent Publication No. 19706/1982 and Japanese Patent Kokai Publication No. 156039/1982 disclose, as a catalyst for ammoxidation, a catalyst comprising antimony oxide, vanadium oxide and an oxide of a metal selected from the group consisting of iron, copper, titanium, cobalt, manganese and nickel. Although this catalyst has a comparatively high selectivity in case of a monoalkyl-substituted heteroaromatic compound, it tends to induce unfavorable reactions such as cleavage of a heteroaromatic ring in case of a dialkyl-substituted heteroaromatic compound so that the selectivity of the desired nitriles is decreased. In addition, this catalyst suffers from decrease of catalytic activity through reduction with ammonia and further its catalytic activity is largely decreased by deposition of carbon.

## SUMMARY OF THE INVENTION

As a result of the extensive study, it has been found that, in the preparation of the heteroaromatic nitriles by ammoxidation of the alkyl-substituted heteroaromatic compounds, the unfavorable reactions such as the cleavage of heteroaromatic rings or dealkylation can be suppressed and the heteroaromatic nitriles can be prepared in a high selectivity even in case of the dialkyl-substituted heteroaromatic compounds when a molybdenum oxide base compound having a specific composition is used as a catalyst, and that said compound has good resistance against heat and reduction.

According to the present invention, there is provided a process for preparing a heteroaromatic nitrile comprising catalytically reacting an alkyl-substituted heteroaromatic compound with molecular oxygen and ammonia in the presence of a catalyst having the following composition:



wherein x, y, z and w represent atomic ratios of phosphorus, an element A defined below, an element B defined below and oxygen to molybdenum, respectively and

(i) x and z are both 0 (zero), y is from 0.1 to 5, and A is at least one element selected from the group consisting of cerium or tungsten, or

(ii) x is from 0.1 to 7, y is from 0 to 5, z is from 0 to 5, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is at least one element selected from the group consisting of thallium, titanium, niobium and aluminum, or

(iii) x is from 0.5 to 7, y is from 0 to 5, z is from 0.01 to 2, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is vanadium, and w is defined from the valencies of molybdenum, phosphorus, the element A, the element B and the values x, y and z.

## DETAILED DESCRIPTION OF THE INVENTION

The catalyst having the composition (I) may be prepared by any of conventional processes for preparing an oxide type catalyst. For example, compounds of the constituent elements of the catalyst are reacted in an aqueous solution, a resulting reaction mixture is evaporated to dryness and the dried product is calcined to obtain the catalyst. The calcination temperature is preferably from 350 to 700 °C. The kind of the compound of each element is not limited and any of conventionally used compounds may be used in the preparation of the catalyst.

Specific examples of the molybdenum compound are ammonium molybdate, ammonium paramolybdate, molybdenum trioxide, molybdenum pentachloride and the like.

Specific examples of the phosphate compound are phosphoric acid, metaphosphoric acid, phosphorous acid, phosphates (e.g. ammonium phosphate, etc.) and the like.

Specific examples of the cerium compound are metal cerium, cerium oxide, cerium nitrate, cerium hydroxide, cerium chloride, cerium carbonate, cerium sulfate and the like.

Specific examples of the manganese compound are metal manganese, manganese oxide, manganese

nitrate, manganese hydroxide, manganese chloride, manganese carbonate, manganese sulfate and the like.

Specific examples of the tungsten compound are ammonium tungstate, tungsten trioxide and the like.

Specific examples of the thallium compound are metal thallium, thallium nitrate, thallium hydroxide, thallium chloride, thallium carbonate, thallium sulfate and the like.

Specific examples of the titanium compound are metal titanium, titanium oxide and the like.

Specific examples of the niobium compound are metal niobium, niobium oxide, niobic acid and the like.

Specific examples of the aluminum compound are metal aluminum, aluminum oxide, aluminum nitrate, aluminum hydroxide, aluminum chloride, aluminum sulfate and the like.

Specific examples of the vanadium compound are ammonium metavanadate, vanadium pentoxide and the like.

The catalyst used according to the present invention may be carried on a carrier such as silica,  $\alpha$ -alumina,  $\gamma$ -alumina, silicon carbide, titanium oxide, diatomaceous earth and zeolite. Among them,  $\alpha$ -alumina and silicon carbide are preferred.

The alkyl-substituted heteroaromatic compound to be converted to the heteroaromatic nitrile according to the present invention includes mono-, di- or trialkyl-substituted pyridines, mono-, di- or trialkyl-substituted pyrazines and the like. Preferred alkyl substituents are lower alkyl groups, e.g. C<sub>1</sub>-straight chain or branched alkyl groups. Specific examples of the alkyl-substituted pyridine are 2-methylpyridine, 3-methylpyridine, 4-methylpyridine, 2,3-dimethylpyridine, 2,4-dimethylpyridine, 2,5-dimethylpyridine, 2,6-dimethylpyridine, 3,4-dimethylpyridine, 3,5-dimethylpyridine, 2-methyl-5-ethylpyridine, 2,4,8-trimethylpyridine, 2,3,4-trimethylpyridine, 2,3,5-trimethylpyridine, 2,3,6-trimethylpyridine and the like. Specific examples of the alkyl-substituted pyrazine are methylpyrazine, ethylpyrazine, 2,3-dimethylpyrazine, 2,5-dimethylpyrazine, 2,6-dimethylpyrazine, 2-methyl-5-ethylpyrazine, 2-methyl-6-ethylpyrazine and the like.

The concentration of the alkyl-substituted heteroaromatic compound in the gaseous reaction mixture may be from 0.15 to 10 % by mole. In the reaction mixture, a molar ratio of the alkyl-substituted heteroaromatic compound, ammonia and molecular oxygen is not critical and preferably in a range of 1:1-100:1.5-20.

As molecular oxygen, air is preferably used although pure oxygen or a mixture of pure oxygen and air may be used.

The gaseous reaction mixture containing the alkyl-substituted heteroaromatic compound, molecular oxygen and ammonia may be diluted with an inactive gas such as steam or nitrogen.

In the process according to the present invention, the reaction temperature is from 300 to 650 °C, preferably from 350 to 600 °C. The space velocity is from 200 to 10,000 hr<sup>-1</sup>, preferably from 300 to 5,000 hr<sup>-1</sup>. Usually, the reaction according to the present invention is carried out under atmospheric pressure, although it may be carried out under reduced or high pressure. The reaction of the present invention is generally performed with a fixed bed reactor, although it may be performed with a fluidized bed reactor.

The present invention will be hereinafter explained further in detail by following examples, in which a conversion and a yield are calculated by following equations:

$$\text{Conversion (\%)} = 100 \times$$

$$\frac{\text{Reacted alkyl-substituted heteroaromatic compound (mole)}}{\text{Supplied alkyl-substituted heteroaromatic compound (mole)}}$$

$$\text{Yield (\%)} = 100 \times$$

$$\frac{\text{Produced nitrile compound (mole)}}{\text{Supplied alkyl-substituted heteroaromatic compound (mole)}}$$

#### Example 1

In distilled water (300 g), ammonium paramolybdate (50 g), cerium nitrate (47 g) and 67.5 % nitric acid (26 g) were added and reacted for 2 hours at 80 °C while stirring. The reaction mixture was concentrated and dried followed by calcination at 550 °C for 5 hours in the air. The resulting catalyst had a composition:

$\text{Mo}_2\text{Ce}_1\text{O}_8$  ( $\text{MoCe}_{0.5}\text{O}_4$ ). The catalyst (10 cc) was filled in a reactor tube having a diameter of 12.6 mm. With heating the catalyst filled portion of the reactor at  $400^\circ\text{C}$ , a gaseous mixture of 2,5-dimethylpyrazine, ammonia, air and steam in a molar ratio of 1:20:10:5 was flowed through the reactor at a space velocity of  $900\text{ hr}^{-1}$ , and the reacted gaseous mixture was trapped by water for 20 minutes after 10 minutes, 1 hour or 10 hours from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 1.

#### Comparative Example

According to the procedures of Example 1 of Japanese Patent Kokai Publication No. 156039/1982, a catalyst of the formula:  $\text{Sb}_4\text{V}_1\text{Ti}_4\text{Si}_7\text{O}_{30.5}$  was prepared, and in the same manner as in Example 1 of the present invention, 2,5-dimethylpyrazine was ammoxidized at  $380^\circ\text{C}$ . The results are shown in Table 1.

#### Example 2

In the same manner as in Example 1, a catalyst having the composition:  $\text{Mo}_{1.5}\text{W}_1\text{O}_{7.5}$  was prepared and 2,5-dimethylpyrazine was ammoxidized in the same manner as in Example 1 but heating the catalyst filled portion of the reactor at  $440^\circ\text{C}$ . The results are shown in Table 1.

Table 1

Example No.	Starting time of trapping	Conversion (%)	5-Methyl-2-cyanopyrazine yield (%)	2,5-Dicyanopyrazine yield (%)	2-Cyanopyrazine yield (%)
1	10 min.	40.9	24.2	10.8	0.9
	1 hr.	41.0	24.6	10.6	0.8
	100 hrs.	41.2	24.5	10.3	0.8
Comparative	10 min.	37.6	18.1	11.3	1.3
	1 hr.	16.2	5.4	4.3	0.0
2	1 hr.	51.5	25.1	18.1	1.1

#### Example 3

In distilled water (300 g), ammonium paramolybdate (80 g) and 85 % phosphoric acid (52 g) were added and reacted for 2 hours at  $90^\circ\text{C}$  while stirring. The reaction mixture was concentrated and dried followed by calcination at  $550^\circ\text{C}$  for 5 hours in the air. The resulting catalyst had a composition:  $\text{Mo}_1\text{P}_1\text{O}_{5.5}$ . The catalyst (10 cc) was filled in the same reactor tube as used in Example 1. With heating the catalyst filled portion of the reactor at  $430^\circ\text{C}$ , a gaseous mixture of 2,5-dimethylpyrazine, ammonia, air and steam in a molar ratio of 1:20:10:5 was flowed through the reactor at a space velocity of  $880\text{ hr}^{-1}$ , and the reacted gaseous mixture was trapped by water for 20 minutes after 10 minutes, 1 hour or 100 hours from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 2.

Table 2

5	Example No.	Starting time of trapping	Conversion (%)	5-Methyl-2-cyanopyrazine yield (%)	2,5-Dicyanopyrazine yield (%)	2-Cyanopyrazine yield (%)
	3	10 min.	35.1	27.1	4.8	0.5
		1 hr.	36.1	27.6	4.9	0.5
10		100 hrs.	34.8	26.9	5.0	0.4

15 Examples 4 to 10

2,5-Dimethylpyrazine was ammoxidized in the presence of a catalyst shown in Table 3 under reaction conditions shown in Table 3. The reacted gaseous mixture was trapped by water for 20 minutes after one hour from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 3.

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Table 3

Example No.	Catalyst composition	Reaction temperature (°C)	SV (hr <sup>-1</sup> )	2,5-Dimethylpyrazine/ ammonia/air/steam (molar ratio)	Conversion (%)	5-Methyl-2-cyanopyrazine yield (%)	2,5-Dicyanopyrazine yield (%)	2-Cyanopyrazine yield (%)
4	Mo <sub>2</sub> P <sub>3</sub> Ce <sub>1</sub> O <sub>15</sub>	380	1,080	1/20/10/5	34.9	27.6	2.9	0.4
5	Mo <sub>2</sub> P <sub>3</sub> Mn <sub>1</sub> O	440	1,050	1/20/10/5	57.9	39.5	10.1	0.4
6	Mo P <sub>3</sub> W <sub>1</sub> Ce O	450	1,100	1/20/10/5	67.8	37.1	23.1	0.3
7	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Ti O	440	1,100	1/20/10/5	67.8	38.9	15.8	0.1
8	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Ti O	440	1,300	1/5/20/15	65.8	40.5	20.2	0.0
9	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Nb O	420	1,300	1/5/20/16	67.9	44.0	16.7	0.0
10	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Al O	440	1,000	1/5/20/10	54.3	43.7	5.3	0.2

Example 11

5 In the same manner as in Example 3 but using the catalyst as used in Example 10 and charging methylpyrazine, ammonia, air and steam in a molar ratio of 1:20:15:5, the ammoxidation was carried out and the reacted gaseous mixture was trapped by water for 20 minutes after one hour from the start of the reaction and analyzed by gas chromatography. A conversion was 86.9 % and a yield of cyanopyrazine was 66.8 %.

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Examples 12 to 15

15 2,6-Dimethylpyridine was ammoxidized in the presence of a catalyst shown in Table 4 under reaction conditions shown in Table 4. The reacted gaseous mixture was trapped by water for 20 minutes after one hour from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 4.

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Table 4

Example No.	Catalyst composition	Reaction temperature (°C)	SV (hr <sup>-1</sup> )	2,6-Dimethylpyridine/ammonia/air (molar ratio)	Conversion (%)	6-Methyl-2-cyanopyridine yield (%)	2,6-Dicyanopyridine yield (%)	2-Cyanopyridine yield (%)
12	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> O	450	910	1/40/40	95.1	55.3	21.9	0.7
13	Mo P <sub>4</sub> W <sub>1</sub> Ce O	450	780	1/40/40	79.1	47.0	11.9	0.5
14	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Al O	450	890	1/40/40	97.5	69.0	17.9	0.5
15	Mo <sub>2</sub> P <sub>3</sub> W <sub>1</sub> Nb O	420	1,400	1/40/40	95.1	75.3	12.7	0.6



Example 16

In distilled water (300 g), ammonium paramolybdate (50 g), 85 % phosphoric acid (49 g) and vanadium pentaoxide (13 g) were added and reacted for 1 (one) hour at 90 °C while stirring. The reaction mixture was concentrated and dried followed by calcination at 550 °C for 5 hours in the air. The resulting catalyst had a composition:  $\text{Mo}_2\text{V}_4\text{P}_2\text{O}_{16}$ . The catalyst (10 cc) was filled in the same reactor tube as used in Example 1. With heating the catalyst filled portion of the reactor at 420 °C, a gaseous mixture of 2,5-dimethylpyrazine, ammonia, air and steam in a molar ratio of 1:20: 10:5 was flowed through the reactor at a space velocity of  $880 \text{ hr}^{-1}$ , and the reacted gaseous mixture was trapped by water for 20 minutes after 10 minutes, 1 hour or 10 hours from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 5.

Table 5

Example No.	Starting time of trapping	Conversion (%)	5-Methyl-2-cyanopyrazine yield (%)	2,5-Dicyanopyrazine yield (%)	2-Cyanopyrazine yield (%)
16	10 min.	32.1	21.1	5.0	0.5
	1 hr.	32.8	22.4	6.0	0.5
	100 hrs.	31.9	21.8	5.8	0.5

Examples 17 to 19

2,5-Dimethylpyrazine was ammoxidized in the presence of a catalyst shown in Table 6 under reaction conditions shown in Table 6. The reacted gaseous mixture was trapped by water for 20 minutes after one hour from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 6.

Examples 20 and 21

2,6-Dimethylpyridine was ammoxidized in the presence of a catalyst shown in Table 4 under reaction conditions shown in Table 4. The reacted gaseous mixture was trapped by water for 20 minutes after one hour from the start of the reaction and analyzed by gas chromatography. The results of the analysis are shown in Table 7.

Table 6

Example No.	Catalyst composition	Reaction temperature (°C)	SV (hr <sup>-1</sup> )	2,5-Dimethyl pyrazine/ammonia/air/steam (molar ratio)	Conversion (%)	5-Methyl-2-cyanopyrazine yield (%)	2,5-Dicyanopyrazine yield (%)	2-Cyanopyrazine yield (%)
17	Mo <sub>2</sub> P <sub>2</sub> V <sub>4</sub> Ce <sub>3</sub> O	380	870	1/20/10/5	31.2	25.0	3.2	0.2
18	Mo <sub>2</sub> P <sub>2</sub> V <sub>4</sub> W <sub>1</sub> O <sub>18</sub>	450	840	1/20/10/5	43.3	27.2	8.1	0.3
19	Mo <sub>2</sub> P <sub>2</sub> V <sub>4</sub> Mn <sub>1</sub> O <sub>17</sub>	430	850	1/20/10/5	40.1	26.2	6.9	0.2

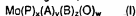
Table 7

Example No.	Catalyst composition	Reaction temperature (°C)	SV (hr <sup>-1</sup> )	2,6-Dimethylpyridine/-ammonia/air/steam (molar ratio)	Conversion (%)	6-Methyl-2-cyanopyridine yield (%)	2,6-Dicyanopyridine yield (%)	2-Cyanopyridine yield (%)
20	Mo <sub>1</sub> P <sub>3</sub> V <sub>1</sub> W <sub>1</sub> O	450	825	1/40/40/0	99.4	57.3	18.3	0.4
21	Mo <sub>1</sub> P <sub>3</sub> V <sub>1</sub> W <sub>2</sub> O	440	1,050	1/50/50/1.6	100	16.3	52.8	0.8

## Claims

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1. A process for preparing a heteroaromatic nitrile comprising catalytically reacting an alkyl-substituted heteroaromatic compound with molecular oxygen and ammonia in the presence of a catalyst having the following composition:



10 wherein x, y, z and w represent atomic ratios of phosphorus, an element A defined below, an element B defined below and oxygen to molybdenum, respectively and

(i) x and z are both 0 (zero), y is from 0.1 to 5, and A is at least one element selected from the group consisting of cerium or tungsten, or

15 (ii) x is from 0.1 to 7, y is from 0 to 5, z is from 0 to 5, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is at least one element selected from the group consisting of thallium, titanium, niobium and aluminum, or

(iii) x is from 0.5 to 7, y is from 0 to 5, z is from 0.01 to 2, A is at least one element selected from the group consisting of cerium, manganese and tungsten, and B is vanadium.

20 and w is defined from the valencies of molybdenum, phosphorus, the element A, the element B and the values x, y and z.

2. The process according to claim 1, wherein the alkyl-substituted compound is at least one compound selected from the group consisting of alkyl-substituted pyridines and alkyl-substituted pyrazines.

3. The process according to claim 2, wherein the alkyl-substituted pyridines are dialkyl-substituted pyridines.

25 4. The process according to claim 2, wherein the alkyl-substituted pyrazines are dialkyl-substituted pyrazines.

5. The process according to claim 1, wherein the catalyst is carried on a carrier.

6. The process according to claim 5, wherein the carrier is  $\alpha$ -alumina or silicon carbide.

7. The process according to claim 1, wherein the reaction temperature is from 300 to 650 °C.

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
A	US-A-2 861 999 (A.F. D'ALESSANDRO) * claim 1 * ---	1,2,5-7	C 07 D 213/84 C 07 D 241/24
P,A	EP-A-0 253 360 (KOEI CHEMICAL CO. LTD.) * claims 1,4,8 * ---	1,2,5-7	
A	US-A-3 970 657 (G.R. ELION et al.) * claims 1,5 * ---	1-3,5	TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
A	US-A-3 970 659 (G.R. ELION et al.) * claims 1,5 * ---	1-3,5	
A	US-A-4 603 207 (R. DICOSIMO et al.) * claim 1 * ---	1,2	
A	PATENT ABSTRACTS OF JAPAN volume 5, no. 20 (C-42) (692), 6th February 1981; & JP - A - 55 145 672 (MITSUWAKA JIYUNYAKU KENKYUSHO K.K.)_13-11-1980 ---	1,2	
A	GB-A-2 093 722 (DEGUSSA AG) * claims 1,6; & JP - A - 57 156 039 (cat. D,A) * -----	1,2	
The present search report has been drawn up for all claims			B 01 J 23/00 C 07 D 213/00 C 07 D 241/00
Place of search BERLIN		Date of completion of the search 20-10-1988	Examiner HASS C V F
<p><b>CATEGORY OF CITED DOCUMENTS</b></p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ***** &amp; : member of the same patent family, corresponding document</p>			